

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008448**Date Inspected:** 29-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi Jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#2

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB019-00-148)

Bay#2- Segment 1AAE

This QA inspector performed MT of seg2E stiffeners weld removal areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector performed MT of seg2E stiffeners excavated repair areas in base metal. ZPMC QC-CWI Li Zhi Jiang and ABFJV Wang Wen Bin were present during observation. The locations are A00 and A41.

This QA inspector performed UT of base metal by zero degree on seg2E stiffeners weld removal areas and edge plate, previously tested and accepted by ZPMC Quality Control personnel. ZPMC QC-CWI Li Zhi Jiang and ABFJV Wang Wen Bin were present during observation. The locations are A00 and A41.

Caltrans Quality Assurance Inspector observed base metal repair by SMAW process, plate detail X179A and plate# PL1472A was repaired, at location A00, without CWR on segment 1AAW. This QA Inspector generated

WELDING INSPECTION REPORT

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TL015 Incident report on this date.

This QA inspector observed the following work in progress:

Bay #3

FCAW welding of weld joint CA58-053, 054 located on Corner assembly CA58. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Liu Wei Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint CA63-021, 022 located on Corner assembly CA63. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Liu Wei Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
